

Blue

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 10:25:59 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 41719	
Estimate Number : 10937	
P.O. Number :	Part Number : D29392
This Issue : 03/09/2008 S.O. No. :	Drawing Number : D2939 REV C - BLUE
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 41441	Material :
Written By :	Due Date : 26/09/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 08.9.03</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: 13 34872

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:59 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41719

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-L 08/09/08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-J 08/09/11

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

-SPRAY PAINT DELFLEET BLUE

-CLEAR DELFLEET

B106729

B105918

B105917

> ml 08 09 24

(4)

(PTU)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08-09-25 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 445

8/9/25

(4x)

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26

Job Completion

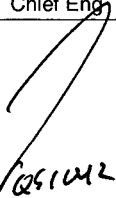
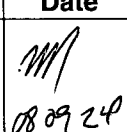
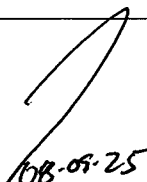
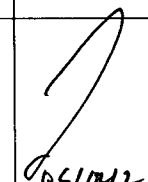
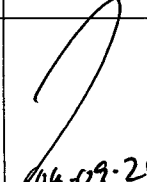


U 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2939-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 41719		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-09-24	7.0	Primer is slightly visible on the edges of the saddle. RC: Primer is slightly lighter in color than the base.	 Q51042	Scuff; repaint per Q51005 Next order, grey primer will be used.	 08-09-24	 08-09-25	 Q51042	 08-09-24

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41719
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

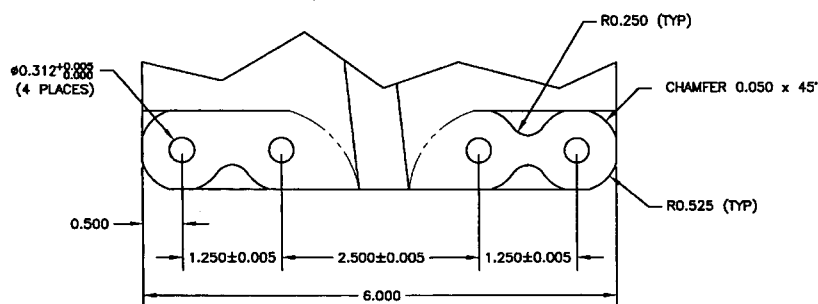
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.123	.123	.123	
B	0.100	0.140		.123	.123	.124	.123	
C	0.100	0.140		.118	.114	.118	.118	
D	0.210	0.230		.223	.223	.224	.225	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.510	.510	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.256	.256	.256	.256	
L	0.312	0.317		.316	.316	.316	.316	
M	0.235	0.240		.238	.238	.238	.238	
N	0.100	0.140		.123	.123	.123	.123	
O	0.540	0.560		.549	.550	.550	.550	
P	0.490	0.510		.504	.504	.500	.500	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.742	2.740	2.740	2.740	
S	0.240	0.270		.245	.250	.250	.250	
T	0.100	0.180		.140	.140	.135	.135	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.320	.320	.720	.720	
X	1.250	1.270		1.265	1.262	1.265	1.265	
Y	1.565	1.585		1.580	1.578	1.576	1.578	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: SJL 08/07/07 / 08/08/08	Date:
Audited by: SJL 08/07/08	Date:
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

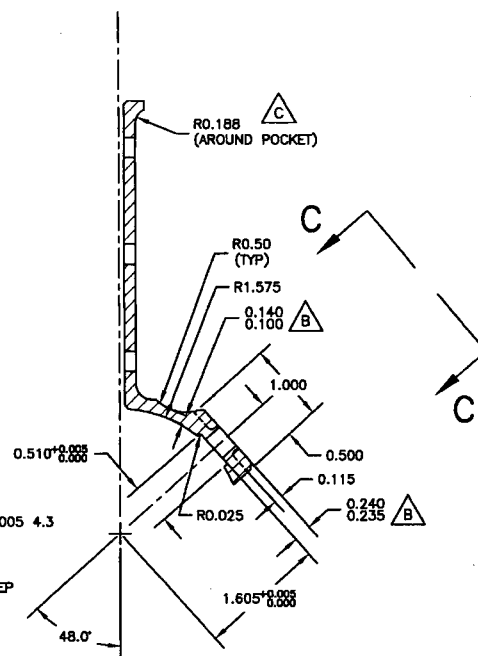


VIEW C-C

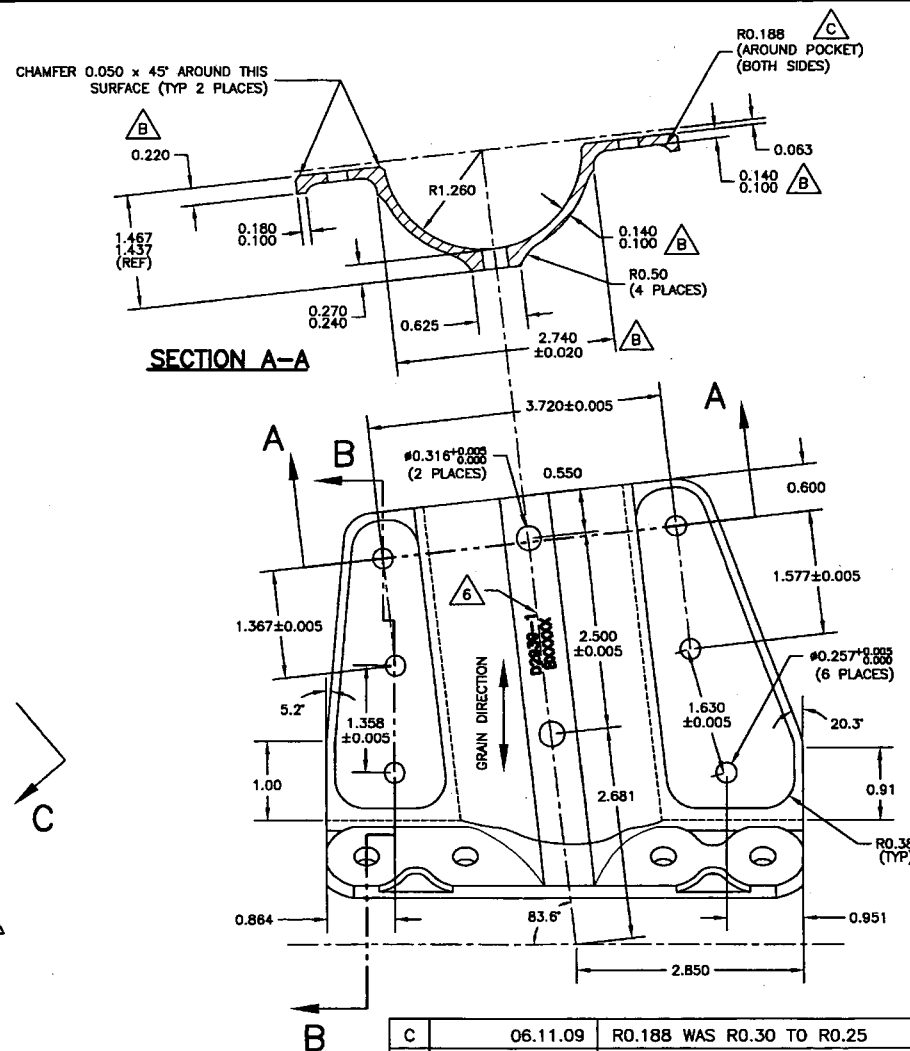
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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BELLINGHAM, WA

DRAWING NO. D2939

SHEET 1 OF 1

SCALE

2:3

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07.02.12